

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006445**Date Inspected:** 22-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu zhi cheng	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG Segment 4AE+4BE	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # SEG 4AE + 4BE

Welding of weld joint -037,038,039,040 located on PCMK BP017-001. Welder is identified as 220067. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint -041,042 located on PCMK BP017-001. Welder is identified as 220063. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint -037 located on PCMK BP018-001. Welder is identified as 220063. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint -037,038,039,040 located on PCMK SP031-001. Welder is identified as 220069. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2233-B-U2-F.

Welding of weld joint –037,038,039,040 located on PCMK SP023-001. Welder is identified as 220069. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint –029,032,034 located on PCMK SP055-001. Welder is identified as 220067. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint –026,029 located on PCMK SP079-001. Welder is identified as 220063. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint –063,064,067,068 located on PCMK SSD27-PP021. Welder is identified as 058174. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –100 located on PCMK SSD27-PP021. Welder is identified as 218976. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Welding of weld joint –145,149,153,157 located on PCMK SSD27-PP022. Welder is identified as 218976. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
